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(I): $\text{RSi}(\text{CH}_3)_2\text{-O-(Si}(\text{CH}_3)_2\text{O)}_n\text{(Si}(\text{CH}_3)(\text{R})\text{O)}_m\text{Si}(\text{CH}_3)_2\text{R}$, wherein in Formula (I), each R is $-\text{R}^1\text{-O(O)-C(R}^2\text{)=CH}_2$, $-\text{R}^1\text{-O-C(R}^2\text{)=CH}_2$ or (a); R^1 is a hydrocarbylene group; each R^2 is independently hydrogen or a methyl or ethyl group; m is a number from about 1 to about 15; and n is a number from about 50 to about 300; and (B) an organosiloxane copolymer represented by the formula (II): $(\text{R}_3\text{SiO})_x(\text{SiO}_{4/2})_y$, wherein in Formula (II), each R is independently a hydrocarbon group or a group represented by the formula: $-\text{O(O)-C(R}^1\text{)=CH}_2$, wherein R^1 is hydrogen or a methyl or ethyl group; x is a number from about 0.25 to about 75; y is a number from about 1 to about 56; and the ratio of x to y is from about 0.3:1 to about 1.5. In one embodiment, the inventive release composition further comprises (C) an acrylate represented by the formula (III): $\text{CH}_2=\text{C(R}^1\text{)-C(O)O-R}^2$, wherein in formula (III), R^1 is hydrogen or a methyl or ethyl group, and R^2 is a hydrocarbon group of about 10 to about 24 carbon atoms. A method of producing release-coated substrates, the release-coated articles thus produced, and multi-layer articles or constructions incorporating a release layer also are disclosed. When the release compositions are cured such as by radiation, the cured compositions exhibit a desirable high and controlled release force at high speeds such as the speeds utilized in label processing.

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Title: Radiation-Curable Organopolysiloxane Release Compositions

This application is a continuation-in-part of U.S. Application Serial No. 08/294,957, filed August 24, 1994, the disclosure of which is incorporated herein by reference in its entirety.

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Technical Field of the Invention

This invention relates to radiation-curable release compositions, and in particular, to electron beam radiation-curable release compositions exhibiting high and controlled release values.

Background of the Invention

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Release coating compositions are used, for example, to coat papers or films which are to be used as a release backing, or a protective release sheet over the adhesive for pressure-sensitive labels, decals, tapes, etc. Labels which are provided with a pressure-sensitive adhesive still adhere to the release coated surface to a sufficient extent to enable the backing sheets with the adhesive labels thereon to be handled. However, it is essential that the labels can be readily separated from the release coated backing sheet without significantly reducing the adhesive forces on the back of the label. When such products are to be used, the release backing sheet is pulled off and discarded. It is desirable to be able to separate labels from the backing sheets at the high speeds normally used in label processing. The exposed pressure-

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sensitive adhesive is pressed onto a surface where the decal or label is to be placed. A common variety of release paper is one wherein one side of the paper (the release side) is coated with a polymeric siloxane material.

5 Silicones and silicone copolymers have been used extensively as release layers on paper, film, etc., because they are inherently low in surface energy. It is desirable that silicone-coated release papers and films have a release force which is low enough to enable the release paper to be easily removed from a pressure-sensitive adhesive-coated substrate but not so low that the release paper will become separated from the pressure-sensitive adhesive coating by forces normally encountered in the
10 processing of the construction such as printing, die cutting and matrix stripping. "Release force" is defined as the amount of force required to peel or separate the release-coated substrate from the adhesive.

 Polysiloxanes containing functional groups which can be radiation cured in the presence or absence of a photosensitizer have been described in various patents
15 as useful silicone release compositions. U.S. Patent 3,726,710 describes radiation-curable release compositions comprising an organopolysiloxane having olefinically unsaturated organic groups and a photosensitizer. The composition may be applied to a paper substrate and cured by exposure to high intensity radiation to produce a release coating.

20 U.S. Patent 4,201,808 describes a release coating composition and release coated material which can be produced by applying to a substrate, for example, paper, a coating of a radiation-curable composition which comprises (a) from 10 to 90 weight percent of an organopolysiloxane containing an average of at least one acryloxy and/or methacryloxy group per molecule, (b) from 90 to 10 weight
25 percent of a low molecular weight acrylyl crosslinker chosen from the group consisting of (i) di-, tri-, and tetra-functional acrylate or methacrylate esters of organic polyfunctional alcohols having a molecular weight of up to about 1200, and (ii) low molecular weight siloxane polyacrylates, and (c) from 0% to about 10% by weight of a photosensitizer.

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The use of polysiloxanes with acrylate or methacrylate ester groups linked to SiC groups as radiation-curable coating materials for sheet-like carriers is described in, for example, U.S. Patents 3,878,263; 4,064,286; 4,963,438; 4,908,274; 4,978,726; and 5,034,491. In the '274 patent, the polysiloxanes are prepared by reacting an epoxy-functional polysiloxane with acrylic or methacrylic acid. In the '726 patent, the polysiloxanes are obtained by reacting an epoxy-functionalized polysiloxane with an acrylic or methacrylic acid and a monocarboxylic acid free of double bonds capable of polymerizing. The '438 patent describes acrylate containing polysiloxanes which are prepared by reacting polysiloxanes containing hydroxy-functional groups with a mixture of acrylic or methacrylic acid and a monocarboxylic acid which is free of double bonds capable of polymerizing.

It is desired to develop release coatings which can be applied to a substrate such as paper and used as a backing for a pressure-sensitive-coated laminate and exhibit high and controlled release values.

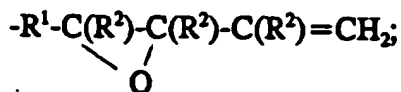
Summary of the Invention

A radiation-curable release composition is disclosed which comprises:

(A) an organopolysiloxane represented by the formula



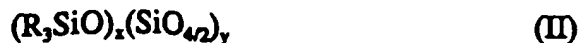
wherein in Formula (I), each R is $-\text{R}^1\text{-O(O)C-C(R}^2\text{)=CH}_2$, $-\text{R}^1\text{-O-C(R}^2\text{)=CH}_2$ or



R^1 is a hydrocarbylene group; each R^2 is independently hydrogen or a methyl or ethyl group; m is a number from about 1 to about 15; and n is a number from about 50 to about 300; and

(B) an organosiloxane copolymer represented by the formula

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wherein in Formula (II), each R is independently a hydrocarbon group or a group represented by the formula



5 wherein R^1 is hydrogen or a methyl or ethyl group; x is a number from about 0.25 to about 75; y is a number from about 1 to about 56; and the ratio of x to y is from about 0.3:1 to about 1.5. In one embodiment, the inventive release composition further comprises

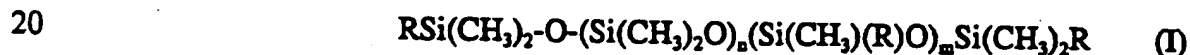
(C) an acrylate represented by the formula



wherein in Formula (III), R^1 is hydrogen or a methyl or ethyl group, and R^2 is a hydrocarbon group of about 10 to about 24 carbon atoms. A method of producing release-coated substrates, the release-coated articles thus produced, and multi-layer articles or constructions incorporating a release layer also are disclosed. When the
15 release compositions are cured such as by radiation, the cured compositions exhibit a desirable high and controlled release force at high speeds such as the speeds utilized in label processing.

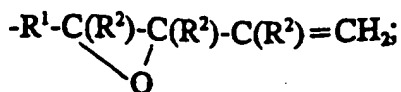
Description of the Preferred Embodiments

The organopolysiloxane (A) can be represented by the formula



wherein in Formula (I) each R is $-R^1-O(O)C-C(R^2)=CH_2$, $-R^1-O-C(R^2)=CH_2$ or

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R¹ is a hydrocarbylene group; each R² is independently hydrogen or a methyl or ethyl group; m is a number from about 1 to about 15, and in one embodiment from about 2 to about 10; and n is a number from about 50 to about 300, and in one embodiment from about 120 to about 150. R can be an acrylate, epoxy or vinyl ether group. In one embodiment, R is $\text{-(CH}_2\text{)}_6\text{OC(O)CH=CH}_2$. In one embodiment R is 4-vinyl cyclohexene epoxide. The hydrocarbylene group R¹ may be a divalent aliphatic, cycloaliphatic or aromatic group containing up to about 10 carbon atoms, and specific examples of hydrocarbylene groups include a methylene, ethylene, propylene, butylene, hexylene, heptylene, cyclohexene, phenylene, etc. R¹ can be an alkylene group of 1 to about 10 carbon atoms. Generally, R² is hydrogen. The organopolysiloxanes of Formula (I) may contain from 3 to about 17 R groups since m is defined as from about 1 to about 15. Thus, the value of m determines the amount of acrylate, epoxy or vinyl ether present in the organopolysiloxanes (A).

The acrylic functional organopolysiloxanes (A) can be prepared, for example, by reacting a siloxane containing hydroxy groups or epoxy groups with acrylic acid or methacrylic acid. The siloxanes containing the 2-hydroxy-1-oxypropylene group can be prepared by reacting a reactive siloxane (e.g., containing halogen) with a polyhydroxy compound such as ethylene glycol, propylene glycol, glycerol, or pentaerythritol.

The epoxy functional organopolysiloxanes (A) can be prepared, for example, by a platinum catalyzed hydrosilation addition reaction between hydrogen atoms on the chain of a polydimethyl-methylhydrogen siloxane copolymer with organic molecules containing both ethylenic unsaturation and epoxide functionality, such as 4-vinylcyclohexene oxide.

The vinyl ether functional organopolysiloxanes (A) can be prepared, for example, by a platinum catalyzed hydrosilation addition reaction between hydrogen atoms on the polydimethyl-methylhydrogen siloxane copolymer with organic

molecules containing two or more ethylenic unsaturated functional groups, such as 1,4-butanediol divinyl ether and trimethylolpropane trivinyl ether.

The organopolysiloxanes (A) are known in the art, and various methods for producing such organopolysiloxanes are described in a number of patents. In particular, the disclosures of U.S. Patents 4,908,274 and 4,963,438 are hereby incorporated by reference for their disclosure of acrylate or methacrylate containing organopolysiloxanes and methods of preparing such organopolysiloxanes. The disclosure in U.S. Patent 4,421,904 is hereby incorporated by reference for its disclosure of epoxy containing organopolysiloxanes and methods of preparing such organopolysiloxanes.

Organopolysiloxanes of the type represented by Formula (I) containing acryloxy groups are available commercially from, for example, Goldschmidt Chemical Corp., Hopewell, Virginia. Goldschmidt's silicone acrylate series include dimethylpolysiloxanes available under the general trade designation TERGO®RC. A particular example of a useful polysiloxane is available under the designation of RC-726. RC-726 is believed to be characterized by Formula (I) wherein each R is $-(CH_2)_6OC(O)CH=CH_2$, m is 6, and n is about 136. The molecular weight of RC-726 is about 11,000. This organopolysiloxane contains about 9% by weight of acrylate.

In one embodiment, the organopolysiloxane is a compound represented by Formula (I) wherein each R is $-(CH_2)_6OC(O)CH=CH_2$, m is 2 and n is about 100. This material contains about 4% by weight acrylate.

Organopolysiloxanes of the type represented by Formula (I) containing epoxy groups are available from the General Electric Co., Waterford, N.Y. A particular example of a useful organic polysiloxane is available under the trade designation UV 9315.

The radiation-curable release compositions of the present invention generally contain from about 10% to about 99% by weight, and in one embodiment about 15% to about 50% by weight of at least one organopolysiloxane (A). In one embodiment, the inventive release compositions contain about 10% to about 25% by

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weight of organopolysiloxane (A), and in one embodiment the concentration is from about 12% to about 18% by weight. In one embodiment, the inventive release compositions contain about 85% to about 95% by weight of the organopolysiloxane (A).

5 The organosiloxane copolymer (B) is a compound represented by the formula



wherein in Formula (II), each R is independently a hydrocarbon group or a group represented by the formula



10 wherein R^1 is hydrogen or a methyl or ethyl group; x is a number from about 0.25 to about 75, and in one embodiment from about 1 to about 75; and in one embodiment about 3 to about 26; y is a number from about 1 to about 56, and in one embodiment from about 10 to about 20; and the ratio of x to y is from about 0.3:1
15 to about 1.5, and in one embodiment about 0.3:1 to about 1.3:1, and in one embodiment 0.7:1 to about 1.5:1, and in one embodiment about 0.8:1, and in one embodiment about 0.65:1. These compounds can have number average molecular weights of up to about 10,000. Each R in Formula (II) can be the same or different
20 and can contain up to about 10 carbon atoms, and in one embodiment about 2 to about 6 carbon atoms. Each R can be independently an alkyl group such as methyl, ethyl, isopropyl, butyl or hexyl; an alkenyl group such as vinyl, allyl or hexenyl; an aryl group such as phenyl, tolyl or xylyl; an aralkyl group such as beta-phenylethyl or beta-phenylpropyl; a cycloaliphatic group such as cyclopentyl, cyclohexyl or cyclohexenyl; or an acrylic group such as acrylate or methacrylate. The copolymer
25 (B) may further comprise from 0.1 to 5% by weight of silicon-bonded hydroxyl groups and may contain R_2SiO units in addition to trace amounts of silicon-bonded

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alkoxy groups such as methoxy, ethoxy or isopropoxy groups. The alkoxy groups can result from the particular method used to prepare the copolymer.

Copolymers of the type represented by Formula (II) are sometimes referred to in the art as MQ resins due to the fact that the group R_3SiO is a monofunctional group and the group $SiO_{4/2}$ is a quadrafunctional group. Organosiloxane copolymers of this type are well known in the art and described, for example, in U.S. Patent 2,676,182, which is incorporated herein by reference for its teachings regarding the preparation of such copolymers. Briefly summarized, these copolymers can be prepared by acidifying an aqueous solution of sodium silicate using a mixture of hydrochloric acid and isopropanol. The resulting acidic silica hydrosol is then treated with a source of $R_3SiO_{1/2}$ siloxane units, such as R_3SiOCH_3 , R_3SiCl or $R_3SiOSiR_3$, dissolved in a mixture of isopropanol and xylene. The molar ratio of $R_3SiO_{1/2}$ units to the $SiO_{4/2}$ units derived from the sodium silicate is from about 0.3:1 to about 1.5:1, and in one embodiment about 0.3:1 to about 1.3:1. After being heated, the reaction mixture is cooled, separated into an aqueous phase, which is discarded, and a nonaqueous phase comprising the siloxane copolymer. The siloxane copolymer is further washed with water to reduce its acid number and to remove water-soluble components, such as isopropyl alcohol. In one embodiment, siloxane copolymer has sufficient acid remaining therein to provide an acid number of from about 0.2 to about 2.

An example of a commercially available copolymer of this type in which the R group is vinyl is available from GE Silicones under the trade designation SL 5030. SL 5030 is described by GE Silicones as being a tight release polymer having a viscosity of 300-600 centistokes at 25°C. Another example is the acrylated organosiloxane copolymer present in RC-708, which is a product of Goldschmidt Chemical that is believed to be a mixture of the dimethylpolysiloxane RC-726 and an acrylated organosiloxane copolymer of the type represented by Formula (II). Other commercially available copolymers that are useful include: SL4406, SL5070 and SL6030 available from GE Silicones; Syl-Off 7602, 7679, Q2-7069 and 7810 available from Dow Corning; PC-290 available from Rhone-Poulenc; and VP1517,

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more often 0% to about 5% by weight based on the total weight of the radiation-curable composition. A photoinitiator is incorporated into the curable compositions when compositions are to be cured by exposure to non-ionizing radiation such as ultraviolet light. Photoinitiators are not required when the curable-release composition is cured by electron beam radiation.

Suitable photoinitiators include those compounds that produce free radicals which operate to polymerize and cure the compositions used in this invention. Examples of photoinitiators which may be used in combination with ultraviolet light includes, for example, benzyl ketals, benzoin ethers, acetophenone derivatives, ketoxime ethers, benzophenone, benzo or thioxanthenes, etc. Specific examples of photoinitiators include: 2,2-diethoxyacetophenone; 2- or 3- or 4-bromoacetophenone; benzoin; benzophenone; 4-chlorobenzophenone; 4-phenylbenzophenone; benzoquinone; 1-chloroanthroquinone; p-diacetyl-benzene; 9,10-dibromoanthracene; 1,3-diphenyl-2-propanone; 1,4-naphthyl-phenyl ketone; 2,3-pentenedione; propiophenone; chlorothioxanthone; xanthone; fluorenone; and mixtures thereof. An example of a commercially available photoinitiator of this type is available from the Ciba Geigy Corporation of Hawthorne, N.Y. under the tradename of Durocure 1173. A particularly effective photoinitiator capable of initiating epoxylated silicone curing reactions is UV 9380C available from General Electric Company of Waterford, N.Y.

The radiation-curable release compositions of the present invention may contain (E) at least one acrylated or methacrylated organic polyhydroxy compound or polyamino compound. These compounds contain at least two acryloyl or acrylyl groups, or at least two methacryloyl or methacrylyl groups which form a network upon polymerization. Suitable compounds useful as component (E) include compounds represented by the general formula



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wherein in Formula (IV), R is derived from a polyhydroxy compound or a polyamine or an organic compound containing hydroxy groups and amino groups, X is hydrogen or methyl, and n is an integer of at least 2 and is preferably 2, 3 or 4. Throughout the specification and claims, the compounds represented by the general Formula (IV) above will be further referred to as "acrylates" or "methacrylates" even though the compounds derived from polyamines form amides and not esters. The polyfunctional hydroxy and amino compounds which are reacted with acrylic or methacrylic acid contain at least 2 and as many as 4 or 5 hydroxy and/or amino groups. Generally the polyfunctional reactants contain from 2 to 4 and more often 2 or 3 hydroxy or amino groups.

The polyfunctional compounds containing at least 2 hydroxyl groups, 2 amino groups or both groups may be monomeric compounds such as ethylene glycol, diethylene glycol, 1,6-hexanediol, neopentyl glycol, trimethylolpropane, pentaerythritol, etc., or similar amine compounds such as ethylene diamine, 1,3-propanediamine, 1,4-butanediamine, 1,6-hexanediamine, dimethylenetriamine, dipropylenetriamine, triethylenetetramene, 5-amino-1-pentanol, and 3-amino-1-propanol. The polyalcohols and polyamines may also be oligomeric compounds such as dimeric, trimeric, or tetrameric polyhydroxy and polyamino compounds.

The acrylated or methacrylated organic polyhydroxy compounds or polyamino compounds (E) used in the release compositions of the present invention generally represented by the above Formula (IV) may be prepared by techniques well known to those skilled in the art such as by the reaction of the polyhydroxy compound or polyamine compound or amino alcohol with acrylic acid or methacrylic acid in amounts to provide the desired di-, tri-, tetra-, or polyacrylated product. The molecular weights of the acrylated or methacrylated products (E) may be as high as 2000 and are generally below about 1200. It is preferred that these acrylated or methacrylated compounds are liquids which are not too viscous so that they will readily be blended into the organopolysiloxane (A) and provide desired fluidity characteristics. In general, these compounds may have viscosities at 25°C of from about 2 to about 2000 cps. The acrylates derived from polyhydroxy compounds

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generally have viscosities at 25°C of from about 2 to about 500 cps, and more preferably between about 2 and 200.

Specific examples of acrylated or methacrylated organic polyhydroxy compounds include, for example, glycerol diacrylate, diethylene glycol diacrylate, 1,6-hexanediol diacrylate (HDODA), triethylene glycol diacrylate, trimethylolpropane triacrylate (TMPTA), neopentylglycol di-, tri-, or tetra-acrylate, tripropylene glycol diacrylate, 1,6-hexanediol dimethacrylate, ethylene glycol dimethacrylate, etc.

Specific examples of acrylated or methacrylated organic polyamino compounds include, for example, N,N'-diacryylethylenediamine, N,N'-diacrylyl-1,3-propanediamine, N,N'-dimethacrylyl-1,6-hexanediamine, etc. Useful acrylated and methacrylated polyhydroxy compounds and polyamino compounds are available commercially. An example of a commercially available acrylated amine product is Uvecryl 7100, an acrylated amine oligomer available from UCB Radcure, Atlanta, Georgia. This acrylate functional oligomeric amine is a liquid having a viscosity in the range of 500-1500 cps at 25°C and theoretical molecular weight of 800.

The radiation-curable release compositions of the present invention may contain from about 0% to about 80%, more often about 10% to about 80%, and in one embodiment about 60% to about 75% by weight of at least one of the above-described acrylated or methacrylated organic polyhydroxy compounds or polyamino compounds (E).

The release compositions of the present invention preferably comprise a mixture of more than one acrylated or methacrylated organic polyhydroxy compound or polyamino compound (E). Such mixtures may comprise two or more derivatives derived from polyhydroxy compounds, or two or more compounds derived from polyamino compounds, or mixtures of one or more compounds derived from a polyhydroxy compound and one or more compounds derived from a polyamino compound. Thus, in one embodiment, component (E) comprises a mixture of (1) from about 40% to about 95% and in one embodiment about 75% to about 90% by weight of at least one acrylated or methacrylated polyamine oligomer and (2) from

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about 5% to about 60% and in one embodiment about 10% to about 25% by weight of at least one acrylated or methacrylated polyhydroxy compound as described above.

5 In another embodiment of the present invention, a portion of the acrylated or methacrylated compound (E) may be replaced by a liquid monoacrylate ester. For example, from about 1% to about 20% by weight of the polyacrylate in
10 the above mixtures may be replaced by a liquid monoacrylate ester to modify the properties of the radiation-curable release composition and, in some instances, the properties of the radiation-cured release composition. The liquid monoacrylate esters generally are characterized by a low viscosity such as from 1 to about 50 cps at
15 25°C, and these monoacrylate compounds are useful to improve the fluidity of the curable release compositions of the invention. Examples of such liquid monoacrylate esters include ethyl acrylate, butyl acrylate, 2-ethylhexyl acrylate, allyl acrylate, n-amyl acrylate, n-octyl acrylate, n-decyl acrylate, benzyl acrylate, cyclohexyl acrylate, diethylaminoethyl acrylate, 2-ethoxyethyl acrylate, n-lauryl acrylate, octadecyl acrylate, etc., the corresponding methacrylates and mixtures thereof.

The radiation-curable release compositions of the present invention are produced by mixing the above-described components. The components may be mixed at room temperature with stirring, and mild heating may be employed in some instances to facilitate mixing. Since the components of the composition may undergo
20 some separation during storage, mild agitation or mixing just prior to use is effective to redisperse the components and is recommended.

The radiation-curable compositions of the present invention can be stabilized against premature polymerization during storage by the addition of conventional polymerization inhibitors such as hydroquinone, monomethylether of
25 hydroquinone, phenothiazine, di-t-butyl paracresol, etc. Amounts of 0.1 weight percent or less of the stabilizers are generally effective.

30 Examples of useful radiation-curable compositions of the present invention are disclosed in the following Tables I-VI. Unless otherwise indicated, in the following examples and elsewhere in the specification and claims, all parts and percentages are by weight, temperatures are in degrees Celsius, and pressures are at

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or near atmospheric pressure. In Tables I-VI all numerical values are in parts by weight.

TABLE I

	<u>Example No.</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>	<u>7</u>
5	RC-726	12	12	18	18	15	--	--
	RC-708	--	--	--	--	--	20	30
	SL 5030	4	8	4	8	6	--	--
	Dodecyl Acrylate	10	10	10	10	10	10	10
	Uvecryl 7100	62.1	58.5	56.7	53.1	57.6	55.8	46.8
10	HDODA	6.9	6.5	6.3	5.9	6.4	9.8	8.3
	TMPTA	5.0	5.0	5.0	5.0	5.0	5.0	5.0

TABLE II

	<u>Example No.</u>	<u>8</u>	<u>9</u>	<u>10</u>	<u>11</u>
	RC-726	67	80	90	95
15	MQOH-6	33	20	10	5

TABLE III

	<u>Example No.</u>	<u>12</u>	<u>13</u>	<u>14</u>	<u>15</u>	<u>16</u>	<u>17</u>
	RC-726	67	80	90	67	80	90
	MQV-4	33	20	10	--	--	--
20	MQDH-1	--	--	--	33	20	10

TABLE IV

	<u>Example No.</u>	<u>18</u>	<u>19</u>	<u>20</u>	<u>21</u>	<u>22</u>	<u>23</u>
	RC-726	67	80	90	70	80	90
	MQOH-4	33	20	10	--	--	--
25	RC-708	--	--	--	30	20	10

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TABLE V

<u>Example No.</u>	<u>24</u>	<u>25</u>	<u>26</u>	<u>27</u>	<u>28</u>	<u>29</u>
UV-9315	67	80	90	67	80	90
MQV-4	33	20	10	—	—	—
5 MQDH-1	—	—	—	33	20	10
UV-9380C	2	2	2	2	2	2

TABLE VI

<u>Example No.</u>	<u>30</u>	<u>31</u>	<u>32</u>	<u>33</u>	<u>34</u>	<u>35</u>
UV-9315	67	80	90	67	80	90
10 MQOH-4	33	20	10	—	—	—
MQOH-6	—	—	—	33	20	10
UV-9380C	2	2	2	2	2	2

15 The radiation-curable release compositions of the present invention generally are applied to a substrate prior to curing. The compositions may be applied to a substrate as a coating by any conventional means known in the coating art such as roller coating, curtain coating, brushing, spraying, reverse roll coating, doctor knife, dipping, die coating, etc. In one particular embodiment, the liquid, radiation-curable compositions of the invention are applied to a substrate using offset gravure techniques. The liquid being applied to the substrate may be heated or cooled to facilitate the coating process and to alter the depth of the penetration of the liquid coated into the substrate prior to curing.

20 A variety of substrates can be coated with the radiation-curable release compositions of the present invention, and these compositions can be applied to any substrate when it is desirable to modify the release properties of a surface of the substrate. For example, the compositions of the present invention can be employed to form release coatings on substrates such as paper, vinyl, polyvinyl chloride films, polyester films, polyolefin films, non-woven fabrics, glass, steel, aluminum, etc. Included among the types of paper which can be used is paper, clay coated paper,

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glassine, polymer coated paper, paperboard from straw, bark, wood, cotton, flax, cornstalks, sugarcane, bagasse, bamboo, hemp, and similar cellulose materials prepared by such processes as the soda, sulfite or sulfate (Kraft) processes, the neutral sulfide cooking process, alkali-chlorine processes, nitric acid processes, semi-chemical processes, etc. Although paper of any weight can be employed as a substrate material, paper having weights in the range of from about 20 to about 150 pounds per ream are useful, and papers having weights in the range of from about 30 to about 60 pounds per ream are presently preferred. The term "ream" as used herein equals 3000 square feet. Examples of specific papers which can be utilized as substrates in preparing the composite laminates of the present invention include Kraft papers such as 40-pound and 50-pound bleached Kraft papers; 41-pound offset grade bleached Kraft paper; etc. The present invention is particularly useful in providing release characteristics to paper and polymeric films.

The amount of radiation-curable release compositions of the invention applied to the various substrates varies depending upon the characteristics of the substrate, the properties desired in the release coating, the radiation source utilized, and the particular formulation of the release composition. If an excess of the coating composition is applied to the substrate, the physical characteristics of the substrate may be affected in an undesirable manner. Also, for economic reasons, it is normally desired to apply the lowest amount of coating to obtain the desired result. Thus, applied coating weights may, depending on the substrate and intended use, range from about 0.1 to about 10 or more grams/m². In general, when it is desired to produce a release-coated paper useful as a protective cover for a pressure-sensitive adhesive tape, applied coating weights are from about 1 to about 3 grams/m². At these levels, desirable high release characteristics are obtained without distorting the essential components of the substrate so that a flat construction which has good performance in the end use can be produced.

The release compositions of the present invention can be cured by exposure to known forms of ionizing or actinic non-ionizing radiation. Useful types of radiation include ultraviolet light, electron beam, x-ray, gamma-ray, beta-ray, etc.

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If ultraviolet light is to be used as the form of radiation, a photoinitiator such as described above is included in the curable release composition. One of the advantages of using radiation to effect cure of the composition is that polymerization takes place rapidly at ambient temperature, and heating is not necessary. The equipment for generating these forms of radiation are well known to those skilled in the art. Electron beam radiation is the presently preferred form of radiation to be used with the compositions of the present invention.

Curing of the release compositions of the present invention can be effected in a continuous manner by passing the release-coated substrate through radiation equipment which is designed to provide the coated substrate with sufficient residence time to complete the cure of the coating. Curing may be effected in an air atmosphere or in an inert atmosphere such as nitrogen or argon. An inert atmosphere is preferred. The length of exposure necessary to cure the release compositions of the present invention varies with such factors as the particular formulation used, type and wavelength of radiation, dose rate, energy flux, concentration of photoinitiator (when required), the atmosphere and thickness of the coating. A total dosage of from about 0.2 to 10 megarads, preferably below 4 megarads is sufficient to cure the silicone release compositions. Generally, the exposure is quite brief and curing is completed in about 0.1 to about 3 seconds. The actual exposure time required to give proper curing for various release compositions can be readily determined by one skilled in the art with a minimum of experimentation. Excess curing of the release compositions should generally be avoided.

Substrates which have been coated with the release compositions of the present invention and cured exhibit desirable high and controlled release properties, the release coating is resistant to moisture and solvents, and the coating is thermally stable. As indicated previously, a substrate which is coated with the cured release composition of the present invention can be used as a protective covering for a second substrate having pressure-sensitive adhesive coating on its surface. The protective covering is normally applied to the adhesive-coated substrate by bringing the two coated substrates into surface-to-surface contact with the release coating on the first

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substrate in contact with the pressure-sensitive adhesive on the second substrate. Application of a slight pressure is usually effective to cause the coated substrates to adhere together forming a four-layered laminate. When a coated release paper prepared in accordance with the present invention is used as a protective covering on a pressure-sensitive adhesive tape, a desirable high-release force is required before the release-coated paper will separate from the adhesive tape, and there is little transfer of the silicone release coating from the paper onto the adhesive. The composition of the present invention is useful particularly to prepare coated papers which are useful in high-speed equipment such as labeling equipment where a high release force is desired at the high peel rates utilized.

Accordingly, the present invention contemplates the use of the compositions described above in the preparation of multi-layer articles or constructions comprising (a) a first substrate; (b) a second substrate; (c) a release layer comprising the release coating composition of this invention which has been cured by exposure to radiation; and (d) a layer comprising a pressure-sensitive adhesive composition, wherein the release layer (c) is interposed between the first substrate and the layer of pressure-sensitive adhesive and is preferentially adherent to the first substrate, and the pressure-sensitive adhesive layer (d) is interposed between the release layer and the second substrate and is preferentially adherent to the second substrate. Additional layers can be interdispersed between the first substrate and the layer of pressure-sensitive adhesive and between the second substrate and the release layer to provide additional desirable properties such as increased strength, increased dimensional stability, etc. As in other applications described above, the first and second substrates may comprise a variety of materials including paper, polyolefins, vinyl, polyester, aluminum, etc., although substrates such as vinyl, polyolefins and paper are preferred.

With reference to the multi-layered articles or constructions utilizing at least one layer of a pressure-sensitive adhesive composition, any pressure-sensitive adhesive composition known in the art can be utilized. Such adhesive compositions are described in, for example, "Adhesion and Bonding", Encyclopedia of Polymer

Science and Engineering, Vol. 1, pages 476-546, Interscience Publishers, 2nd Ed. 1985. Such compositions generally contain an adhesive polymer such as natural, reclaimed or styrene-butadiene rubber, styrene butadiene or styrene isoprene block copolymers, polyisobutylene, poly(vinyl ether) or poly(acrylic) ester as a major constituent. Other materials may be included in the pressure-sensitive adhesive compositions such as resin tackifiers including, for example: rosin esters, oil-soluble phenolics, or polyterpenes; antioxidants; plasticizers such as mineral oil or liquid polyisobutylenes; and fillers such as zinc oxide or hydrated alumina. The selection of the pressure-sensitive adhesive to be used in any particular multi-layer article or construction is not critical to this invention, and those skilled in the art are familiar with many suitable pressure-sensitive adhesives. However, as known to those skilled in the art, the pressure-sensitive adhesive and the release layer should not chemically react.

The radiation-curable release compositions of this invention provide cured coatings and films which have excellent release characteristics, and when applied to a substrate such as paper, the coated paper exhibits improved dimensional stability under varying conditions such as temperature, humidity, aging, etc. A particularly desirable property of substrates such as paper which have been coated with the release compositions of this invention and constructions such as labels prepared therefrom is that they lay flat and remain flat over time, even when exposed to moisture and low or high temperatures. The surface characteristics of the coated construction allows for printing by laser printers providing good toner anchorage and printing by flexographic techniques, when used in combination with generally available primers, print inks and over-varnishes.

The improved high release properties exhibited by the release compositions of this invention at high operating speeds are illustrated by applying the compositions of Examples 1-7 to 40-pound Kraft paper at an approximate coating weight of one pound per ream. The coatings are cured by exposure to an electron beam. The coated side of the coated paper is then laminated under pressure to the

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adhesive side of a liner of 40 pound Kraft paper coated with a hot melt, rubber-based adhesive.

After aging the laminate for 3 days at room temperature (i.e., about 23°C) or at 140°F, as indicated in Table VII below, the release force, measured in grams per inch width, required to separate the laminates at the release coating-adhesive interface by pulling the tape from the liner at an angle of 90° is determined at peel rates of 300 inches per minute or 12 inches per minute as indicated below. The results are summarized in Table VII. In Table VII each numerical value is in grams of force per inch and is based on the average value for four test specimens.

TABLE VII

<u>Example No.</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>	<u>7</u>
<u>Test Speed/Storage</u>							
300 in/min							
3 days @ RT	16.5	26.5	10.5	18.3	17.0	15.7	16.5
3 days @ 140°F	25.3	54.3	22.3	39.0	34.0	27.5	29.7
12 in/min							
3 days @ RT	19.0	18.0	7.5	12.0	11.0	27.5	16.0
3 days @ 140°F	42.5	50.5	20.5	30.5	36.0	75.5	46.0

The release compositions of Examples 8-20, 22 and 25-35 are applied to 40-pound Kraft paper at an approximate weight of one pound per ream. The coatings of Examples 8-20 and 22 are cured by exposure to an electron beam. The coatings of Examples 24-35 are cured by exposure to UV light. The coated side is then laminated under pressure to the adhesive side of a liner of 40-pound Kraft paper coated with one of the following adhesives:

Adhesive A--Rubber-based adhesive dissolved in solvent.

Adhesive B--Acrylic adhesive dissolved in solvent.

Adhesive C--Removable emulsion acrylic adhesive.

Adhesive D--Permanent emulsion acrylic adhesive.

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After aging the laminate for three days at room temperature (i.e., about 23°C), the release force, measured in grams per inch width, required to separate the laminates at the release coating-adhesive interface by pulling the tape from the liner at an angle of 90° is determined at a peel rate of 12 inches per minute. The results are summarized in Table VIII. In Table VIII, each numerical value is in grams of force per inch and is based on the average value for four test specimens.

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TABLE VIII

		<u>Adhesive</u>			
<u>Example No.</u>		<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>
5	8	113.7	135.4	84.5	102.9
	9	83.8	102.6	71.1	79.6
	10	60.6	84.5	70.5	58.5
	11	49.3	67.3	59.7	55.1
	12	—	258	505	381.4
10	13	182.4	145.6	249.6	235.4
	14	85.8	101.7	140.2	125.2
	15	—	235.2	512.8	369.7
	16	178.7	161.7	324.6	258.6
	17	130.7	101.7	186.3	152.1
15	18	—	289.9	585.6	419.5
	19	136.5	169.6	348.9	282.3
	20	117.2	139.1	189.4	177.7
	22	64.9	91.2	—	—
	25	154.1	291.6	290.6	284.4
20	26	79.7	222.4	235.3	268
	27	225.7	131.8	299.7	318.4
	28	161	98	285.6	263.1
	29	95.1	124.3	267.5	256.2
	30	—	138.56	369.6	323.4
25	31	95.2	95	265.1	215.1
	32	66	141.9	308.1	199.5
	33	108.8	75.5	131.7	94.9
	34	32.2	44.9	86	83.8
	35	22.5	27.1	92.6	69.1

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While the invention has been explained in relation to its preferred embodiments, it is to be understood that various modifications thereof will become apparent to those skilled in the art upon reading the specification. Therefore, it is to be understood that the invention disclosed herein is intended to cover such modifications as fall within the scope of the appended claims.

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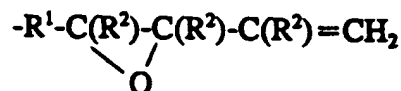
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Claims

1. A radiation-curable release composition, comprising:
 (A) an organopolysiloxane represented by the formula



5 wherein in Formula (I), each R is $-\text{R}^1\text{-O(O)C-C(R}^2\text{)=CH}_2$, $-\text{R}^1\text{-O-C(R}^2\text{)=CH}_2$ or



10 R^1 is a hydrocarbylene group; each R^2 is independently hydrogen or a methyl or ethyl group; m is a number from about 1 to about 15; and n is a number from about 50 to about 300; and

- (B) an organosiloxane copolymer represented by the formula



wherein in Formula (II), each R is independently a hydrocarbon group or a group represented by the formula



wherein R^1 is hydrogen or a methyl or ethyl group; x is a number from about 0.25 to about 75; y is a number from about 1 to about 56; the ratio of x to y is from about 0.3:1 to about 1.5.

- 20 2. The composition of claim 1 further comprising
 (C) an acrylate represented by the formula



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wherein in Formula (III), R^1 is hydrogen or a methyl or ethyl group, and R^2 is a hydrocarbon group of about 10 to about 24 carbon atoms.

3. The composition of claim 1 further comprising

(D) a photoinitiator.

4. The composition of claim 1 further comprising

(E) at least one acrylated or methacrylated organic polyhydroxy compound or polyamino compound.

5. The composition of claim 1 wherein in Formula (I), R^1 is an aliphatic, cycloaliphatic or aromatic group of up to about 10 carbon atoms.

6. The composition of claim 1 wherein in Formula (I), each R^2 is hydrogen.

7. The composition of claim 1 wherein in Formula (I), R is $-(CH_2)_mOC(O)CH=CH_2$, m is in the range of about 1 to about 15, and n is in the range of about 50 to about 300.

8. The composition of claim 1 wherein in Formula (I), R is $-(CH_2)_6OC(O)CH=CH_2$, m is 6, and n is about 136.

9. The composition of claim 1 wherein in Formula (I), R is $-(CH_2)_6OC(O)CH=CH_2$, m is 2, and n is about 100.

10. The composition of claim 1 wherein R is 4-vinyl cyclohexene epoxide.

11. The composition of claim 1 wherein R is vinyl ether.

12. The composition of claim 1 wherein in Formula (II), R is an acrylic group.

13. The composition of claim 1 wherein in Formula (II), R is a vinyl group.

14. The composition of claim 2 wherein in Formula (III), R^1 is hydrogen and R^2 is a hydrocarbon group of about 10 to about 18 carbon atoms.

15. The composition of claim 3 wherein said photoinitiator (D) is a compound selected from the group consisting of: 2,2-diethoxyacetophenone; 2- or 3- or 4-bromoacetophenone; benzoin; benzophenone; 4-chlorobenzophenone; 4-

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phenylbenzophenone; benzoquinone; 1-chloroanthroquinone; p-diacetyl-benzene; 9,10-dibromoanthracene; 1,3-diphenyl-2-propanone; 1,4-naphthyl-phenyl ketone; 2,3-pentenedione; propiophenone; chlorothioxanthone; xanthone; fluorenone; and mixtures of two or more thereof.

- 5 16. The composition of claim 4 wherein component (E) is a compound represented by the formula



10 wherein in Formula (IV), R is derived from a polyhydroxy compound or a polyamine or an organic compound containing hydroxy groups and amino groups, X is hydrogen or methyl, and n is an integer of at least 2.

- 15 17. The composition of claim 4 wherein component (E) is a compound selected from the group consisting of glycerol diacrylate, diethylene glycol diacrylate, 1,6-hexanediol diacrylate, triethylene glycol diacrylate, trimethylolpropane triacrylate, neopentylglycol di-, tri-, or tetraacrylate, tripropylene glycol diacrylate, 1,6-hexanediol dimethacrylate, ethylene glycol dimethacrylate, and mixtures of two or more thereof.

18. The composition of claim 4 wherein component (E) is an acrylated amine oligomer.

- 20 19. A radiation-curable release composition, comprising:
 (A) an organopolysiloxane represented by the formula



wherein in Formula (I), each R is $-R^1-O(O)C-C(R^2)=CH_2$, R^1 is a hydrocarbylene group, R^2 is hydrogen or a methyl or ethyl group, m is a number from about 1 to about 15, and n is a number from about 50 to about 300;

- 25 (B) an organosiloxane copolymer represented by the formula

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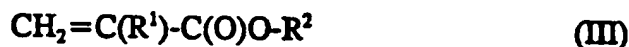


wherein in Formula (II), each R is independently a hydrocarbon group or a group represented by the formula



- 5 wherein R^1 is hydrogen or a methyl or ethyl group; x is a number from about 0.25 to about 75; y is a number from about 1 to about 56; the ratio of x to y is from about 0.3:1 to about 1.3:1; and

(C) an acrylate represented by the formula



- 10 wherein in Formula (III), R^1 is hydrogen or a methyl or ethyl group, and R^2 is a hydrocarbon group of about 10 to about 24 carbon atoms.

20. A radiation-curable release composition, comprising:

(A) an organopolysiloxane represented by the formula



- 15 wherein in Formula (I), R is $-(CH_2)_6OC(O)CH=CH_2$, m is a number in the range of about 2 to about 10 and n is a number in the range of about 120 to about 150;

(B) an organosiloxane copolymer represented by the formula



- 20 wherein in Formula (II), each R is independently an acrylic or a vinyl group; x is a number from about 1 to about 75; y is a number from about 1 to about 56; and the ratio of x to y is from about 0.3:1 to about 1.3:1;

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(C) dodecyl acrylate;

(E-1) an acrylated amine oligomer; and

(E-2) at least one compound selected from the group consisting of glycerol diacrylate, diethylene glycol diacrylate, 1,6-hexanediol diacrylate, triethylene glycol diacrylate, trimethylolpropane triacrylate, neopentylglycol di-, tri-, or tetraacrylate, tripropylene glycol diacrylate, 1,6-hexanediol dimethacrylate, ethylene glycol dimethacrylate, and mixtures of two or more thereof.

21. A method of producing a release coated substrate which comprises

applying a coating of the composition of claim 1 to a substrate; and
curing the coating on the substrate by exposing the coating to radiation.

22. The method of claim 21 wherein the composition is cured with an electron beam.

23. A release-coated article comprising a substrate which has been coated with the release composition of claim 1 and which has been cured by exposure to radiation.

24. The release-coated article of claim 23 wherein the substrate is paper.

25. A multilayer article comprising

(a) a first substrate;

(b) a second substrate;

(c) a release layer comprising the release composition of claim 1 which has been cured by exposure to radiation; and

(d) a pressure-sensitive adhesive layer, wherein the release layer (c) is interposed between the first substrate and the layer of pressure-sensitive adhesive (d) and is preferentially adherent to the first substrate, and the pressure sensitive adhesive layer (d) is interposed between the release layer and the second substrate and is preferentially adherent to the second substrate.

26. The multilayer article of claim 25 wherein the first and second substrates are paper.